

Thursday, 9/21/2006 3:22:33 PM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : OH-58 SKIDTUBE  
Job Number : 28689  
Estimate Number : 11650  
P.O. Number : *NIA* Part Number : D058672012  
This Issue : 9/21/2006 S.O. No. : *NIA* Drawing Number : N/A  
Prsht Rev. : NC Project Number : N/A  
First Issue : *NIA* Type : LANDING GEAR Drawing Revision : N/A  
Previous Run : 28688 Material : *NIA*  
Written By : Due Date : 10/20/2006 Qty: 1 Um: Each  
Checked & Approved By : *[Signature]*  
Comment : Est Rev:G 02.06.27 Re-format; CHG002 (MPP 2251); ECN 258 K  
J

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photo Copy Blue files and Type Labels as per PPP D058-672-012 CHG002

*KJ 06-09.28* (V)

2.0 28689A OH-58 SKIDTUBE ASSEMBLY



Comment: Sub-Component 1 D058-672-041 OH-58 SKIDTUBE ASSEMBLY

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 D2968043 Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 1 D2968-043 Tow Ring *28268*

5.0 D2935 Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 2 D2935 Saddle Spacer *328265*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 28689

Part Number: D058672012

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 2 D2934

Saddle Spacer

B28264

7.0

D29332

206 Saddle Right



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 2 D2933-2

Saddle

B28263

8.0

D29322

206 Saddle Right side



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 2 D2932-2

Saddle

B28859

9.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 10 D2712

Set Screw

B26481

10.0

D2659

Lug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 2 D2659

Lug Assembly

B28254

11.0

D2652

Bushing



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 24 D2652

Bushing

B28252

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN337A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 4 AN3-37A Bolt M14478

13.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 8 AN3-41A Bolt M102239

14.0

AN46A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 12 AN4-6A Bolt M101418

15.0

AN510A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 4 AN5-10A Bolt M101840

16.0

AN512A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

✓ 4 AN5-12A Bolt M101943

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

AN960JD10

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
✓ 12	AN960JD10	Washer	M100743

18.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
✓ 24	AN960JD416	Washer	M102337-

19.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
✓ 8	AN960JD516	Washer	M102328-

20.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
✓ 1	AN970-4	Washer	M100101-

21.0

MS21042L3

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty	Part Number	Description	Batch
✓ 12	MS21042L3	Nut (or -3)	M101917-

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LP Date: 06/11/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 28689

Part Number: D058672012

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total: 13.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

✓ 13 MS21042L4 Nut (or -4)

M19185-

PU 6/11/09 (1)

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

CB 06/11/10 (1)

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D058-672-012

Location: \_\_\_\_\_

PPP Rev: A

CB 06/11/10

(1)

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

CB 06/11/10

Job Completion



U 26.11.10

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 0H-58 SKIDTUBE ASSEMBLY
Job Number	: 28689A		
Estimate Number	: 10475		
P.O. Number	: N/A	Part Number	: D058672041
This Issue	: 9/21/2006	Drawing Number	: D2922 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: A1
Previous Run	: 28688A	Material	: N/A
Written By	: <i>[Signature]</i>	Due Date	: 10/20/2006
Checked & Approved By	: <i>[Signature]</i>	Qty:	1 Um: Each
Comment	: Est Rev:C 01.06.28 Re-format; ECN 258 KJ Est Rev:D 06.02.06 Added D18025 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP D058-672-041

CHG 001

KJ 06-09-23 (1)

2.0

D2620

Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2620

Bent Tube 3" OD

B28457 Pm '06-10-10 (1)

3.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

Pm '06-10-10 (1)

2-Weld D2794 cap as per QSI 004 and Dwg D2922. Use aluminum rod.

A/R

Aluminum Rod

M101655/M101010 BE 06-10-10

3-Cut aft end of D2620 bent tube as per dwg D2922

Pm '06-10-11 (1)

4-Drill pilot holes using drill jig DT8480 and DT8025 open to 0.312" dia.

Pm '06-10-11 (1)

5-Drill holes for wearplates using DT 8487 Open to 0.297" dia.

Pm '06-10-11 (1)

6-Drill holes for aft cap as per Dwg D2922 using drill jig DT 8025. Open using #6 Drill Bit

Pm '06-10-11 (1)

8-Remove inner indexing ridge on aft end of skidtube as per Dwg D2922

Pm '06-10-11 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 28689A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9-Deburr and Blow out all chips form inside the tube

*pm 06-10-11(1)*

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



*pm 06-10-11(1)*



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

5.0

D2923

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2923 Web

*B28667*

*B28667*

*pm 06-10-13(1)*

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2922(without cutting fluid)

*pm 06-10-11(1)*

2-Countersink crossbolt spacer holes as per Dwg D2922(without cutting fluid)

*pm 06-10-11(1)*

3-Deburr and Blow out all chips from inside the tube

*pm 06-10-11(1)*

4-Bond D2923 web in place as per QSI 015. Ensure holes lineup

A/R Sikaflex-291

*m102107*

Sikaflex expire date: *07-02-01*

*pm 06-10-13(1)*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*DP*

*06-10-16*

8.0

D2794

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty

Part Number Description

1 D2794 Fwd Cap

Batch

*B14400*

*BE 06-10-10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 0H-58 SKIDTUBE ASSEMBLY

Job Number: 28689A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

D2649

Crossbolt Spacer



Comment: Qty.: 22.0000 Each(s)/Unit Total: 22.0000 Each(s)

Pick:

Qty Part Number Description Batch

22 D2649 Crossbolt spacer

*228250 BE 06-10-17*

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld D2649 cross bolt spacers as per QSI 004 and Dwg D2922.(Remember to back drill each hole to 0.250" before welding the other side)

A/R Aluminum Rod

*M101010 BE 06-10-17*

3-Grind welds flush as per Dwg D2922

*Pm 06-10-17*

4-Counterbore 5/16" x 0.750" deep as per Dwg D2922

*Pm 06-10-17*

11.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

*Job 1025*

*PD 06-10-17*

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*M101575*

*yl 06/11/02 x1*

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Q.m 06/11/03*

*(1)*

14.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

5 D2648-3 Wearpad

*B27169*

*Q.m 06/11/03*

*(1)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 28689A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2656-15 Wearshoe

B2482/5

16.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2656-21 Wearshoe

B27075

17.0

D2924

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2924 Wearshoe

B27927

18.0

MS27039108

Screw



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number Description

Batch

50 MS27039-1-08 Screw

M102404

19.0

AN960JD10L

Washer



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number Description

Batch

50 AN960JD10L Washer

M100233

a.m. 06/11/03

(1)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 28689A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

ALS41032130

Insert



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number Description Batch

50 ALS4-1032-130 Insert M18990  
or (see QSI 017)

21.0

D26511

Plug



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

20 D2651-1 Plugs B28251

22.0

D26513

O-Ring



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

20 D2651-3 O-Rings B28401

23.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap B28041

24.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-1-08 Screw M162464

a.m 06/11/03 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/11/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 28689A

Part Number: D058672041

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD10L Washer *M100223*

*a.m. 06/11/03 (1)*

26.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Insert a drop of Sikaflex at insert hole before installing wearplates.

A/R Sikaflex-291 *M102107*

Sikaflex expire date: *02/07*

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2922

3-Install D2646 Aft Cap and seal with Sikaflex adhesive. Clean excess adhesive

A/R Sikaflex-291 *M102107*

Sikaflex expire date: *02/07*

*a.m. 06/11/03 (1)*

3- Wing Walk as per Dwg D2922 and QSI 005 4.4

*102098*

*06/11/08* Batch:

27.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

*06/11/08 (1)*

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *NA 06/11/05*

29.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*06/11/10*

Job Completion



*06/11/10*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2922	REV. A SHEET 1 OF 2
DATE 99.10.14		TITLE OH-58 SKIDTUBE ASSEMBLY	SCALE NTS
A	99.10.14	NEW ISSUE	
A1	[Signature] 01.08.20	Ø0.640 WAS Ø0.625	

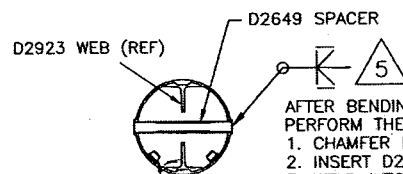
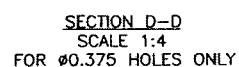
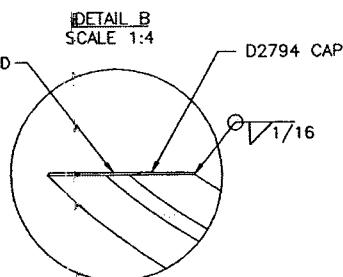
RELEASED  
00.05.11 [Signature]

Qty	Part Number	Description
X	D2922-041	SKIDTUBE ASSEMBLY
*	D2600-1	EXTRUSION
1	D2646	AFT CAP
4	D2648-3	WEARPAD
1	D2648-5	WEARPAD
22	D2649	CROSS BOLT SPACER
20	D2651-1	PLUG
20	D2651-3	O-RING
1	D2656-15	WEARSHOE
1	D2656-21	WEARSHOE
1	D2794	CAP
1	D2923	WEB
1	D2924	WEARSHOE
50	AKS7-1032-130 or AKS4-1032-130 or ALS7-1032-130 or ALS4-1032-130	INSERT
52	AN960JD10L	WASHER
52	MS27039-1-08	SCREW

**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2600-1 EXTRUSION REQUIRED BEFORE BENDING = 160 INCHES.\*
- 3) INSERT D2923 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8406 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL AKS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN ALL INSERTS. SEAL WITH SIKAFLEX-241/291.
- 5) WELDING TO BE DONE PER DART QSI 004.
- 6) FINISH:  
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2923 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 0.50 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 7) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (20 PLACES).

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 28689A



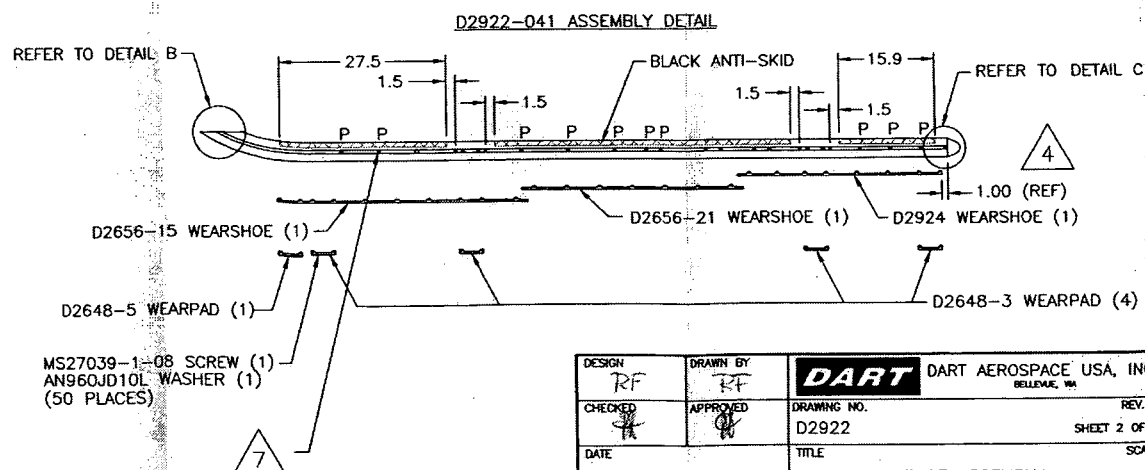
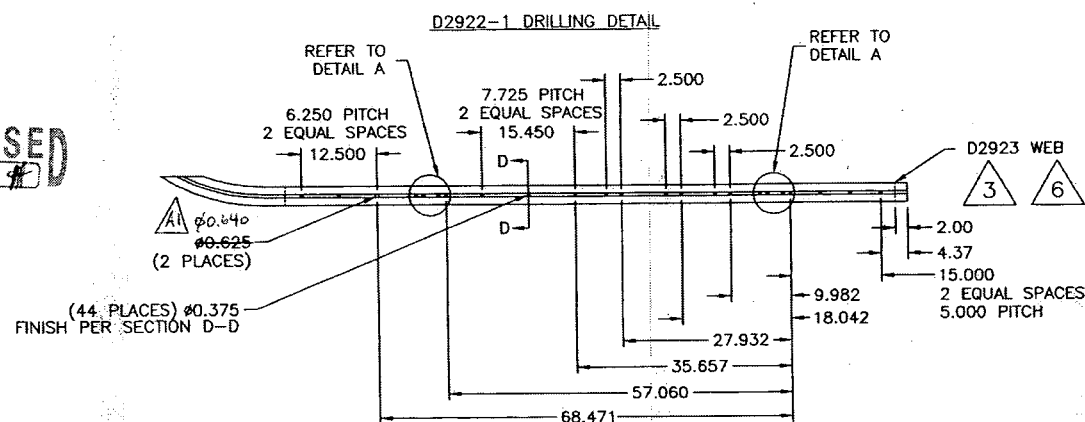
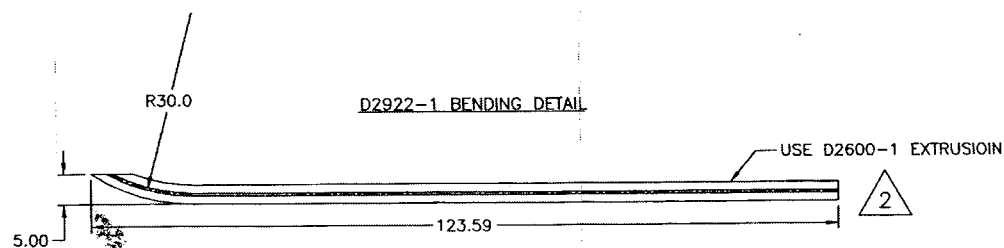
AFTER BENDING AND DRILLING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:

1. CHAMFER HOLE 0.030 X 45°
2. INSERT D2649 SPACER (22 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2649 SPACER TO Ø0.313 X 0.75 DEEP

032-130 (REF)  
(PLACES)

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DESIGN RF	DRAWN BY RF	<b>DART</b> DART AEROSPACE USA, INC. BELLVILLE, WA
CHECKED JA	APPROVED JW	
DRAWING NO. D2922		REV. A SHEET 2 OF 2
DATE 99.10.14	TITLE OH-58 SKIDTUBE ASSEMBLY	SCALE 1:24





NO. 35

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Barclay Elliott  
Joint Welding Procedure Tig  
Part number and Job number AO58672041 1/B28687 A

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig  
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐  
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input checked="" type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input checked="" type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input checked="" type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input checked="" type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐  
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/10/16 Qualifier David Arredondo